



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3144-3

Job Sheet 211848



Part No: D3144-3

Job Qty: 1 pcs

Part Name: Doubler



Part Weight: 0 lbs

Job Created: 7/29/20

Due Date: 8/4/20

Type: SOLD

Note: DWG REV C SHEET 1 IPP Rev:A 11.03.30 now made in house DD verf:EC

Ship Via:

Status: New

Job Tracking No:

Created By: Linda Lacelle

Description:

POSITIVE RECALL

EFFECTIVE 20/07/20 AUTH S10

RELEASED 20-08-05 DATE 10

Priority: Medium

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1 <i>USE DXF D3144-3 Custom</i>	<i>Req'd</i> pcs			0.17	0.12	Waterjet - Flow		<i>20/07/30</i>
110	QC 2	1 pcs			0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		<i>20/07/30</i>
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-6200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S291200



Part: D3144-3

Job No: 211848

Serial No/Batch: S291200

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 07/30/20

			QC 2 - 65	
			QC 2 - 5	
			QC 2 - 71	
			QC 2 - 73	
			QC 2 - 69	
			QC 2 - 76	
			QC 2 - 86	
			QC 2 - 83	
120 QC 8	1	0.00 0.00	QC 8 - 12	
	pcs		QC 8 - 14	
			QC 8 - 17	
			QC 8 - 20	
			QC 8 - 25	
			QC 8 - 3	
			QC 8 - 32	
			QC 8 - 33	
			QC 8 - 35	
			QC 8 - 39	
			QC 8 - 4	
			QC 8 - 44	
			QC 8 - 45	
			QC 8 - 49	
			QC 8 - 58	
			QC 8 - 8	
			QC 8 - 9	
			QC 8 - 68	
			QC 8 - 67	
			QC 8 - 1 (A)	
			QC 8 - 47	
			QC 8 - 40	
			QC 8 - 52	
			QC 8 - 23	
			QC 8 - 57	
			QC 8 - 76	
			QC 8 - 61	
			QC 8 - 66	
			QC 8 - 73	
			QC 8 - 82	
140 Handfinish - 1-1 Chemical- B4B	1	0.00 0.06	Handfinish - 1 - 1 - B4B	
	pcs		Handfinish - 1 - 2 - B4B	
			Handfinish - 1 - 3 - B4B	
			Handfinish - 1 - 4 - B4B	
			Handfinish - 1 - 5 - B4B	
			Handfinish - 1 - 6 - B4B	
			Handfinish - 1 - 7 - B4B	
			Handfinish - 1 - 8 - B4B	
			Handfinish - 1 - 9 - B4B	
			Handfinish - 1 - 10 - B4B	
			Handfinish - 1 - 11 - B4B	
			Handfinish - 1 - 12 - B4B	
			Handfinish - 1 - 13 - B4B	
			Handfinish - 1 - 14 - B4B	
			Handfinish - 1 - 15 - B4B	
			Handfinish - 1 - 16 - B4B	
			Handfinish - 1 - 17 - B4B	
			Handfinish - 1 - 18 - B4B	
			Handfinish - 1 - 19 - B4B	
			Handfinish - 1 - 20 - B4B	
			Handfinish - 1 - 21 - B4B	

DAS
 1111 3 1 2020 40
 9-89

150 Powdercoat - 4 Black Sand - B4B 1 pcs

Handfinish - 1 - 22 - B4B

0.00 0.02

Powdercoat - 1 - B4B

Powdercoat - 2 - B4B

Powdercoat - 3 - B4B

Powdercoat - 4 - B4B

Powdercoat - 5 - B4B

Powdercoat - 6 - B4B

Powdercoat - 7 - B4B

Powdercoat - 8 - B4B

Powdercoat - 9 - B4B

Powdercoat - 10 - B4B

160 QC 3 1 pcs

0.00 0.00

QC 3 - 10

QC 3 - 13

QC 3 - 15

QC 3 - 17

QC 3 - 18

QC 3 - 2

QC 3 - 28

QC 3 - 3

QC 3 - 30

QC 3 - 34

QC 3 - 36

QC 3 - 41

QC 3 - 51

QC 3 - 58

QC 3 - 59

QC 3 - 68

QC 3 - 9

QC 3 - 40

QC 3 - 19

QC 3 - 43

QC 3 - 24

QC 3 - 61

QC 3 - 81

QC 3 - 82

QC 3 - 87

170 Packaging 3-1 - Stock - B4B 1 pcs

0.00 0.00

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 - B4B

Packaging 3 - 11 - B4B

Packaging 3 - 12 - B4B

Packaging 3 - 13 - B4B

Packaging 3 - 14 - B4B

Packaging 3 - 15 - B4B

Packaging 3 - 16 - B4B

Packaging 3 - 17 - B4B

Packaging 3 - 18 - B4B

Packaging 3 - 19 - B4B

Packaging 3 - 20 - B4B

Packaging 3 - 21 - B4B

Packaging 3 - 22 - B4B

Packaging 3 - 23 - B4B

Spacedown

2020/08/04

20-08-5

AUG 05 2020

DAS 40

SAD 20/08/04

180 QC 21 - SA	1 pcs	0.00 0.00	Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 37 - B4B	
			QC 21 - SA - 21	DAS
			QC 21 - SA - 70	21
			QC 21 - SA - 9	9-89
			QC 21 - SA - 77	

AUG 06 2020

Part Op 100 - 1-Cut as per Dwg Dwg Rev: C custom Prog Rev: C custom 2-Deburr if necessary

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

140 - Chemical Conversion Coat per QSI005 4.1

150 - Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 START TIME: 8:15 M156440 OVEN TEMPERATURE: 320°

FINISH TIME: 8:45

160 - QC3- Inspect Part Finish

170 - Identify as per dwg & Stock Location: Location: CA2

180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.032	2024-T3 .032 Sheet	.2120 sf (.212 ea)	100-Waterjet - Flow - 1	3137570

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.032	0	73	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	0.129inches + 0.005 - 0.001	0.134 0.128	Diameter	
2	Doubler	0.400inches ± 0.030	0.430 0.370		
3	Doubler	28.500inches ± 0.030	28.530 28.470		
4	Doubler	0.032inches ± 0.010	0.042 0.022		

Plex 7/29/20 2:56 PM dart.lacelle.linda

78 Date: Aug 11/2020



NCR No. 20-8260

Route update only

Job: <u>211848</u> Part No. <u>D3144-3</u>		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☒ Water Jet ☐ Supplier Quality ☐					
Date : <u>JUL 31 2020</u>		Sequence #: <u>110</u>		QTY Affected : <u>1</u>			MRB (QSI042) <u>SAs</u> <u>C-10/2/30</u> Completed By <u>DE 20/07/30</u> Lead hand / Supervisor <u>AD 20-08-05</u> QC / QA Coordinator <u>AD 20-08-05</u>		
Description Work Order Deviation <u>Omit Hole #1 and the Last hole on Part</u> <u>USE DXF D3144-3 Customer Rev. C</u> <u>Part is 0.454 wide, Drawing is asking for 0.400</u> <u>Part was always at this dimension</u>				Disposition <u>Acceptable</u> <u>Acceptable</u>					
Root Cause Operator ☒ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled				FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☒ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread					
Other/Details:									